



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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269T9312

Job Sheet 181449



Part No: 269T9312

Job Qty: 21 ea

Part Name: Wrench Install 269A1315 Nut



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 10/19/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 269T9312 REV:5 IPP REV A 18.07.25 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	21 Ea	10/19/18	10/19/18	0.00	0.00	Start Up Small Fab-4		MCL
100	Small Fab	21 pcs	10/19/18	10/19/18	0.08	1.05	Small Fab-9		MCL DAS
110	QC	21 pcs	10/19/18	10/19/18	0.00	0.00	QC5		38
120	QC	21 pcs	10/19/18	10/19/18	0.00	0.00	QA		DAS 9-09
130	Packaging	21 pcs	10/19/18	10/19/18	0.00	0.00	Packaging3-2		21
140	QC21-FG	21 Ea	10/19/18	10/19/18	0.00	0.00	QC21		21 3-09

Part Op 100 - Assemble
Descriptions: 130 - Identify and Stock

OCT 10 2018
OCT 10 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
269T9312-30K	Wrench Inst.Nut	21 Ea (1 ea)	90-Start up Operation	3100142
269T9312-5	Stop	21 Ea (1 ea)	90-Start up Operation	3102167
91400A191	Machine Screw 8/32 Unc X 5/16 Ss	63 (3 ea)	90-Start up Operation	3105580

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	269T9312-3	21	0	0
	269T9312-5	21	0	0
	91400A191	63	0	0

Part Specifications



Container No: S117013



Part: 269T9312

Job No: 181449

Serial No/Batch: S117013

Revision: 5

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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www.dartaerospace.com

ot be found.

Plex 7/26/18 11:54 AM Dart.lajeunesse.marie

Date: 10/10/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

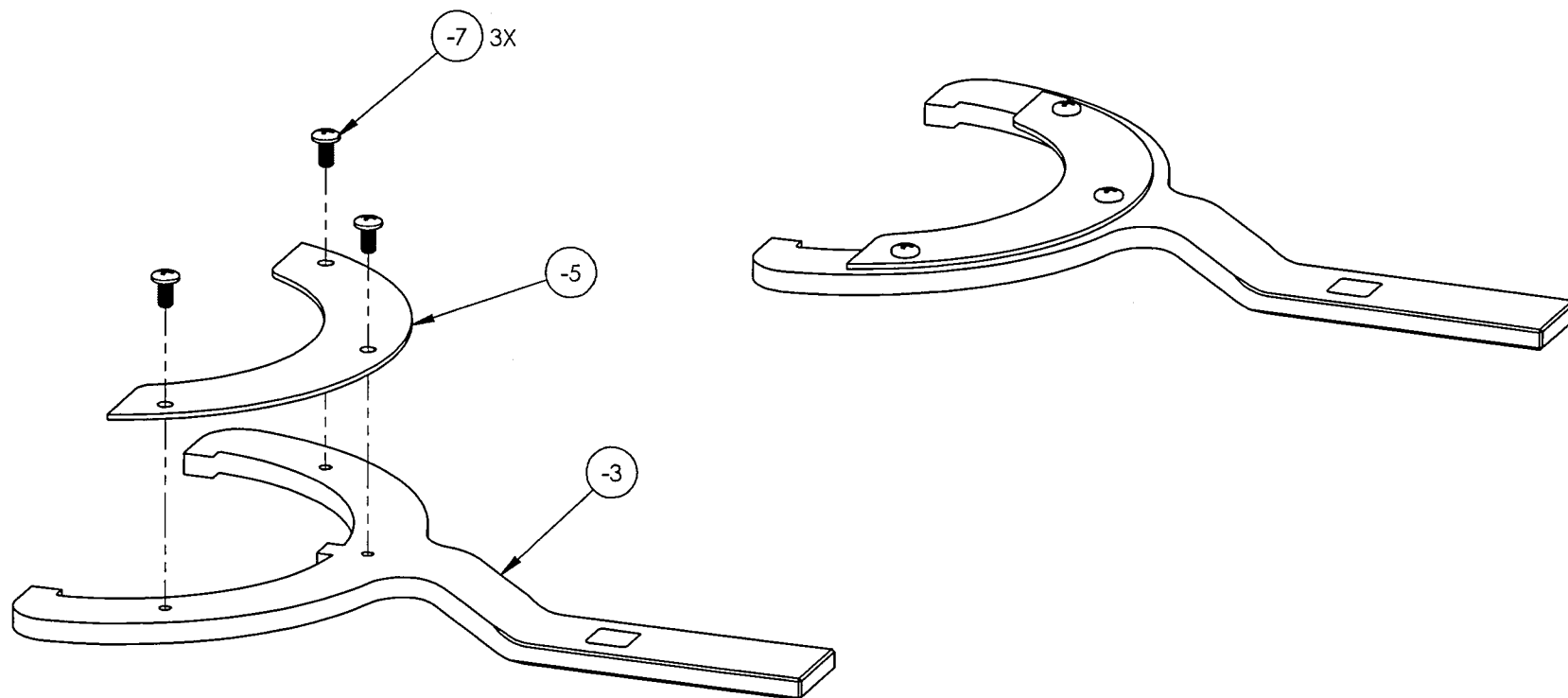
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		DWG No. WAS 269A9312.	2/19/90	-	-
2		SCREWS CHANGED FROM AN515-BR5	-	-	-
3		CHANGED TO ALTERNATE METHOD WITH HOLES FOR STRESS RELIEF.	10/10/2007	WP	G.E.
4		CH'D ENGRAVE NOTE.	6/9/2009	RJC	-
4A		CREATED WELDMENT & RENUMBER COMPONENTS.	9/9/2011	SE	RW
5	15-0296	UPDATED TO NEW DRAFTING STANDARDS. -3 ADDED DIM 2X .670 MIN. CH'D DIM WAS 2X .503-.511 IS 2X .503-.508.. -3 & -5 CH'D FINISH WAS BLACK OXIDE IS BLACK ZINC ASTM B633 TYPE II SC2.	9/11/2015	DPD	JAG



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-3	1	WRENCH	4130/4140/4142		2/3
			-5	1	STOP	4130/4140/4142		4
		B/O	-7	3	SCREW	STEEL	8/32 X 5/16 (MCMASTER-CARR #91400A191)	1

DART AEROSPACE	
TITLE 269A1315 NUT INSTALLATION WRENCH	
DWG NO. 269T9312	REV 5
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 5° .X ± .1	DRAWN BY: GILBERT APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL 269
SCALE 1:2	DATE 1/18/2012 SHEET 1 OF 4

DQA: _____ Date: _____



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Work Order update only ☐

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Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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